

5/12

DART AEROSPACE LTD	Work Order:	22679
Description: Hub Sleeve	Part Number:	D3233-5
Dwg: D3233 Rev. B	Qty:	5

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.03.15	4
2	CL	Turn as per Dwg D3233 Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020 SRA or AMS 5075 or AMS 5077 (M1020TR1.875W.250) <b>Identify for D3233-5</b>			
		Batch: M17015	CPL	05.03.31	4
3	QC2	Inspect parts as they come off the machine <b>Identify as D3233-5</b>	EZ	05.03.31	5
4	CM	Mill as per Dwg D3233	EZ	05.03.31	5
5	QC8	Second check	KJ	05.04.01	5
6	CM	Deburr	EZ	05.04.01	5
7	QC5	Inspect work to Step 6.	KJ	05.04.01	5
8	ST	Identify and Stock	CPL	05.04.01	5
9	AC	Cost / part 29.44	SAC	05.04.06	5
10	DC	Close W/O 29.44 Inspect Level 21	KJ	05.04.12	5

Rev	Date	Change	Revised By	Approved
A	05.03.14	New issue	KJ/JLM	JLM

RELEASED  
05/05/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

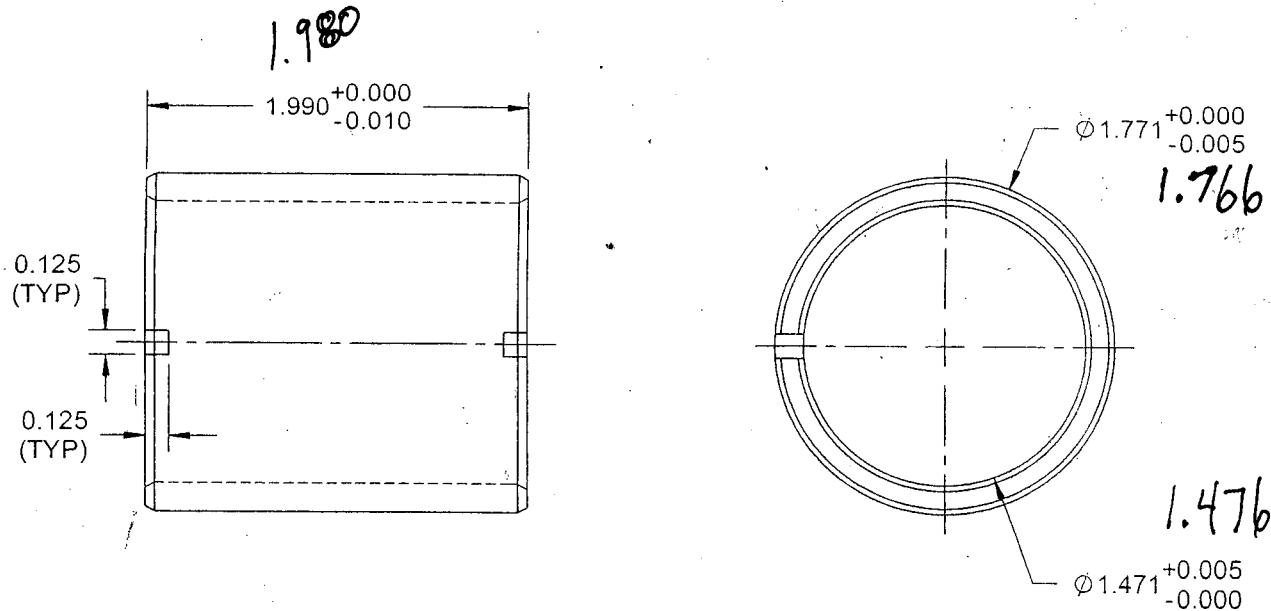
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

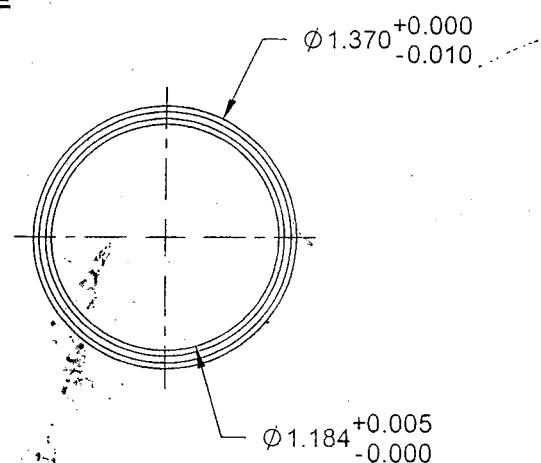
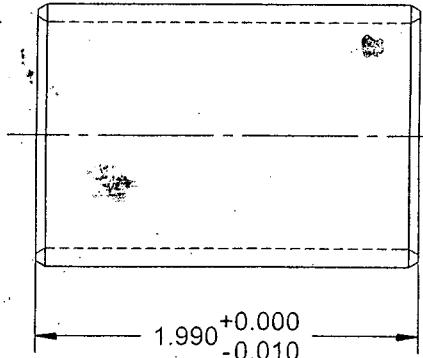
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

36  
**PRELIMINARY ISSUE**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3233</b>	REV. B SHEET 3 OF 3
DATE	05.03.08	TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1



**D3233-5 HUB SLEEVE**



**D3233-7 SHAFT SLEEVE**

**SHOP COPY**

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ENGINEERING

UNCONTROLLED COPY

AMENDMENT  
WITHOUT NOTICE

**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

**WORK ORDER  
NO. 22679**

~~1.853-1.770~~

1.472 - 1.419

1.472 - 1.424 = .048

1.856-1.857

~~0.175~~      ~~0.175~~      ~~0.175~~

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyMar 14, 2005  
08:26 am

Work Order No : 0022679  
 Project Name : D3233-5  
 Project For : WK512  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3233-5  
 Description : Hub Sleeve  
 Manufactured : No  
 Amount Req'd : 0  
 Amount Done : 0  
 Start Date : 03-11-05  
 Est Finish Date : 03-30-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:  
 Burden Flags : NNNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00

Order Entry No :  
 OE Value : 0.00

Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
* Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00